

Work Order ID 85974

85974

Page 1

Item ID: D2582

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg Assembly

Start Date: 19/06/2012 Start Qty: 6.00

Required Date: 26/06/2012 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2582	Rev B								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D2582 and								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Identify as per dwg & Stock Location: <u>WA</u>								
Packaging	Memo <u>Step Cell</u>	0.00							
Packaging									

**6*4*
**6*4*

4x

GB
12/07/10

Salatu

/ 12-07-11

4

φ

Ae

12.07.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85974***85974***

Page 2

June-19-12 11:59:26 AM

Item ID: D2582

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg Assembly

Start Date: 19/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21 - Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

CK 12/7/12

12-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 11:59:29 AM

Page 1

Work Order ID: 85974

85974

Parent Item: D2582

D2582

Parent Item Name: Step Leg Assembly

Start Date: 19/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:F Removed Manufacturing 05-11-07 JLM
IPP Rev:G Added part # to Sub 06-08-10 JLM
IPP Rev H New pick list 08.01.11 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2278 *D2278* Step Leg		Manufactured	No			100	Each	8.0000	2	12	**	EP 12/07/10	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			8						
				72830			8						
D2279 *D2279* Step Spacer		Manufactured	No			100	Each	6.0000	1	6	**	EP 12/07/10	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			6						
				73048			6						
D2322 *D2322* Step Spacer		Manufactured	No			100	Each	12.0000	1	6	**	EP 12/07/10	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			12						
				67611			4						
				73055			8						
D3720-1 *D3720-1* Step Spacer		Manufactured	No			100	Each	7.0000	1	6	**	EP 12/07/10	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			7						
				72831			7						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 11:59:29 AM

Page 2

Work Order ID: 85974

85974

Parent Item: D2582

D2582

Parent Item Name: Step Leg Assembly

Start Date: 19/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

D3720-2 Manufactured No

100 Each 10.0000 1 6

D3720-2

Step Spacer

**

Location

Loc Qty

Loc Code

GA

10

72829

10

MS20470AD4-4

Purchased No

100 Each 9,451.000 22 132

MS20470AD4-4

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST313

4418

122027

2600

122063

1818

ST319

5033

116188

136

116391

66

118614

1000

119109

26

121011

5

121556

800

121652

3000

MS20470AD4-5

Purchased No

100 Each 1,246.000 4 24

MS20470AD4-5

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST319

1246

116410

18

118405

405

120142

823

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85974 MLJ
12/06/19

D2278 STEP LEG
(2 PLACES)

MS20470AD4-4 RIVET
(5 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2278 STEP SPACER

D2322 STEP SPACER
MS20470AD4-4 RIVET
(6 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2582 STEP LEG ASSEMBLY

MS20470AD4-5 RIVET
(2 PLACES)

B
D3720-2 STEP SPACER

C'SINK ON INSIDE
GRIND RIVET FLUSH TO
SURFACE AS REQUIRED
(BOTH SIDES)

MS20470AD4-5 RIVET
(2 PLACES)

B
D3720-1 STEP SPACER

RELEASED
06-01-10

D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs

B	REPLACE D2280 SPACERS WITH D3720-1/-2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT.	PH	07.12.27
A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B D2582 SHEET 1 OF 1 TITLE SCALE STEP LEG ASSEMBLY NTS COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	PH		
CHECKED	LS		
MFG. APPR.	LS		
APPROVED	LS		
DE APPR.	LS		
DATE	07.12.27		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries